Work Order I January-30-14 11:4		01		*112	501*						Page 1
Item ID: D34 Revision ID: Item Name: Was	411-3			Accept	*N900	040	100)* s	etup Sta	. 14	S1* S2*
		tart Qty: 50.00 keq'd Qty: 50.00	*50* *50*		Cust Item I Customer:	D:					. ,,
		MLJ	•	Tooling: SPC (Y/N):		nte:		R	tun Sta Sto	D ~1/J	R1* R <i>2</i> *
Sequence ID/ Work Center ID	De	peration escription		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio										
D3411	REV A			0.00			··				
*100 *100* Hardinge Hardinge CNC Lathe Sm	nall	Memo Turn as per Deburr & Te	Folio FA591 Rev: 各介 & umble as per Dwg D3411	0.00	_			<u>55</u>	_ф_		<u> SFC 2014-02-05</u>
110	Q	C2- Inspect parts off m	nachine FAI/FAIB	0.00							•
110 QC Quality Control		Memo		0.00				<u>55</u>	_Φ_		<u>JFC 201</u> 4-02-05
120 *1 2 0*	Q	C8- Inspect parts - sec	ond check	0.00				5 <i>5</i>	6		DAG Os
QC Quality Control		Memo		0.00						:	aman L 14/02/05

DQA:			Date:										
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS	
Work orac	•				_	Rework			Skid-tube Crosstube	Г]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is			moforming Finishing			e/Packaging	Other
NCR N	۱o. ِ					Suspected Unapproved	napproved Large Fab Composite					Supplier	
Root					Desci	ription of work order update	Ī	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data							Ì					- -	
Equip/Tooling													
Handling/Pre													
Material		!											
Operator													
Offset/Setup													
Process													
Supplier													
Training							l						
Transport													
Unapproved				<u> </u>									
							FA	ULT CA	TEGORY				
Landi	ng (_	General	_	,		_	7	-	¬
		Bending			_	Bend	┕	4	Program	_	Outside Dim	-	Pressure/Forced
		Centre No	ot Concer	ntric	\vdash	BOM/Route		Grain		_	Over/Under	⊢	Set-up
		Cracks				Broken/Damage/Defect		Hardwa		L	Part Incorre		Temperature/Cure
	 	Crimp/Kir	nk/Ripple	/Wave		Burrs		1 '	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	Weld
:	<u></u>	Cuffs				Contamination		-1	tions Incomplete/Unclear	<u>_</u>	Part Moved	L	Wrong Stock Pulled
		Crushing			_	Countersink	L	1 '	gned/off center	<u></u>	Positioned V		-
	<u> </u>	Heat Trea				Cut Too Short	L	Mislab			Power Loss/	Surge	Other
		Inspection		Tube		Drawing	L	Misrea					
	_	Marks/Ch				Drill Holes		Off-set					
		Turning S				Finish		4	Calibration				
	1	Wave/Tw	ist in Tub	oe -		Fit/Function		Out of	Sequence				

Work Order ID 112501 *112501* January-30-14 11:47:05 AM Item ID: D3411-3 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Washer **Start Qty:** 50.00 *50* **Start Date:** 1/28/14 **Cust Item ID:** Required Date: 1/30/14 Req'd Qty: 50.00 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Date: **Approvals:** Stop SPC (Y/N): Date: Date:

Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** Identify as per dwg & Stock Location: ST 642 130

120 Packaging

Memo

0.00

Packaging

140

140

QC

QC21- Final Inspection - Work Order Release

0.00

0.00 Memo

Quality Control

MLJ 14-02-06

Page 2

DAS

26

9-89

DQA:			Date:							DAIDT			
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	PDATE			AEROSPACE
QA Closed:			Date:					,		V	Vork Order up	odate only	
Work Orde	ar:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Orac	•					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	CR No.		_	Suspected Unapproved			Large Fab	Composite		Supplier			
Root					Desci	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design													
Doc/Data				:			ļ						
Equip/Tooling													
Handling/Pre	Ш												
Material													
Operator													
Offset/Setup													
Process	Ш												
Supplier							İ						
Training							İ						
Transport													
Unapproved													
							FA	ULT CA	TEGORY				
Landi		l				General		J		Г	¬	. –	7
	Ш	Bending	_		<u> </u>	Bend	<u> </u>	1	Program	-	Outside Dim	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		_	Over/Under	<u> </u>	Set-up
	\vdash	Cracks			<u> </u>	Broken/Damage/Defect	_	Hardwa			Part Incorre	· · · -	Temperature/Cure
;	\vdash	Crimp/Kir	nk/Ripple	/Wave		Burrs	_	1	ion Incomplete/Un	· –	Part Lost/M		Weld
	\vdash	Cuffs				Contamination	<u> </u>	4	tions Incomplete/U	inclear	Part Moved	<u></u>	Wrong Stock Pulled
	igdash	Crushing			<u> </u>	Countersink	\vdash	1 1	gned/off center	· -	Positioned V	_	٦
		Heat Trea			<u> </u>	Cut Too Short	-	Mislabe		L	Power Loss/	Surge	Other
	-	Inspection	•	Tube	<u> </u>	Drawing	\vdash	Misrea					
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set					
	_	Turning S			<u> </u>	Finish	<u> </u>	4	Calibration				
1		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence				

Picklist Print

January-30-14 11:47:05 AM

Page 1

Work Order ID:

112501

Parent Item:

D3411-3

Parent Item Name:

Washer

Start Date: 1/28/14

Required Date: 1/30/14

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP A05.10.19New issueKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	27.0000	0.0136	0.71579			
Delrin Round Bar 1"													
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT039		27			*****				
				m12	7442	27			0.7	159 JH	201	4-02-	o5

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:		-		_			W	ork Order up	odate only		-
Work Orde	er:					DISPOSITION			AGAINST	ΓDE	PARTMENT	/PROCESS		
						Rework			Skid-tube Crosstube		1	Water Jet	\neg	Engineering
Part N	No.					Scrap			Machining Small Fal		Pro	d. Eng. Coor.	┪	Quality
	•					Use-as-is			moforming Finishing	3	4	re/Packaging		Other
NCR I	۱o.					Suspected Unapproved	roved Large Fab Compos		~ — · · · · · · · · · · · · · · · · · ·					
Root	Ī				Desc	scription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre				'			1							
Material			!											
Operator														
Offset/Setup	Щ													
Process	Ш													
Supplier	Щ						ļ							
Training														
Transport						•								
Unapproved														
							FA	ULT CA	TEGORY					
Landi					_	General	_	,		_	7	_		
		Bending			\perp	Bend		1	Program	<u> </u>	Outside Dim	-	_	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	L	Grain		L	Over/Under			Set-up
		Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		<u>_</u>	Part Incorre	⊢		Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	_	Burrs	L	1 '	ion Incomplete/Unqualified	<u></u>	Part Lost/Mi	ssing	_	Weld
	_	Cuffs				Contamination		4	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink	<u> </u>	•	gned/off center	\vdash	Positioned V			l
		Heat Trea				Cut Too Short	_	Mislab			Power Loss/	Surge		Other
	-	Inspection	-	Tube		Drawing		Misrea						
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes	L	Off-set						
	<u></u>	Turning S			L	Finish		Out of	Calibration					
	<u> </u>	Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	112501
Description: Washer	Part Number:	D3411-3
Inspection Dwg: D3411 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments	.L
Ø0.875	+/-0.010	0.815	✓		Caliper	JFC-01	,
Ø0.203	+0.005/-0.001	0.206					, , , , , ,
0.063	+/-0.0	0.064	V		١,١		
							. 4.4
							1
	,						
							. ,
							·

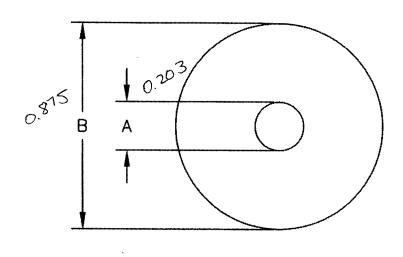
Measured by:	200	Audited by:	mm/L 00	Prototype Approval:	N/A
Date:	2014-02-05	Date:	14/02/05 00	Date:	N/A

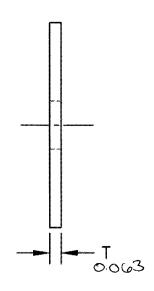
Rev	Date	Change			Appro	oved	J
Α	09.10.16	New Issue	KJ 🛁	7) A]
				1		1, 1	4



DESIG	CP	DRAWN BY	DART	AEROSPACE PORT HADLOCK		INC.
CHEC	KED III	APPROVED ,	DRAWING NO.			REV. A
	M	世	D3411		SHEE	T 1 OF 1
DATE			TITLE			SCALE
05.0	3.16		WASHER,	DELRIN		NTS
A		05.03.16	NEW ISS	:UE		

SPECIFICATION CONTROL DRAWING





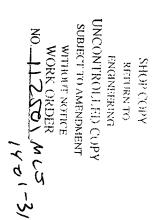
1) SPECIFICATION: DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH	BOLT	Α	В	T (in)	NON-METALLIC
NO.	SIZE	(in)	(in)	±0.006	REPLACEMENT FOR:
-3	#10	0.203	0.875	0.063	AN970-3
-4	1/4	0.265	1.125	0.063	AN970-4
-5	5/16	0.328	1.375	0.063	AN970-5
-6	3/8	0.390	1.625	0.063	AN970-6
-7	7/16	0.453	1.812	0.109	AN970-7
-8	1/2	0.515	2.000	0.109	AN970-8

- 2) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES





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